

Date:
User:Tuesday, 11/13/2007 1:24:16 PM
Kim Johnston

Process Sheet

Split
80 07/12/20

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 35050 -2
 Estimate Number : 13009
 P.O. Number : N/A
 This Issue : 11/13/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 34552
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 07-09-11 JLM Verified By: EC
 Est Rev: b ECN 1052 07-10-31 DD verified by:

Part Number : D3245042
 Drawing Number : D3245 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 11/28/2007
 Qty: 6 Um: Each

TC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0 D32452 Panel

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Panel
Batch: B 350047

3.0 D32455 Angle Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Angle Plate
Batch: B 350047 x 6 B 350043 x 3
AS 07/12/19

4.0 235018C3Y RIGID RECEPTACLE

Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)
RIGID RECEPTACLE
Batch: M106037
AS 07/12/19

5.0 MS20427M33 Rivet

Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)
Rivet
Batch: M101840 x 21 M105728 x 75
M105740 x 90 ✓
Double check

Tuesday, 11/13/2007 1:24:17 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 35650

Part Number: D3245042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20615M33

3-M3

Rivet



All same



Comment: Qty.: 9.0000 Each(s)/Unit Total : 54.0000 Each(s)
Rivet

M 100.077

AS 07/12/19

(X6)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245

mf 07-12-20

(G)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/20

(X6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock
Location: X 183

AS 07/12/20

(X6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/12/21

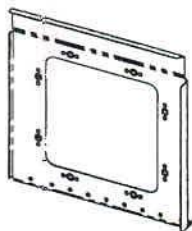
(G)

Job Completion



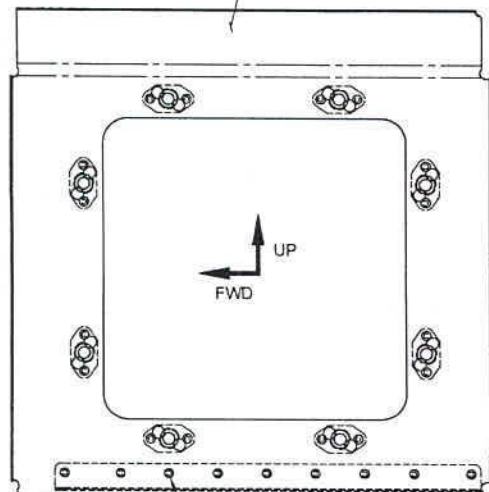
mf 07/12/21

U



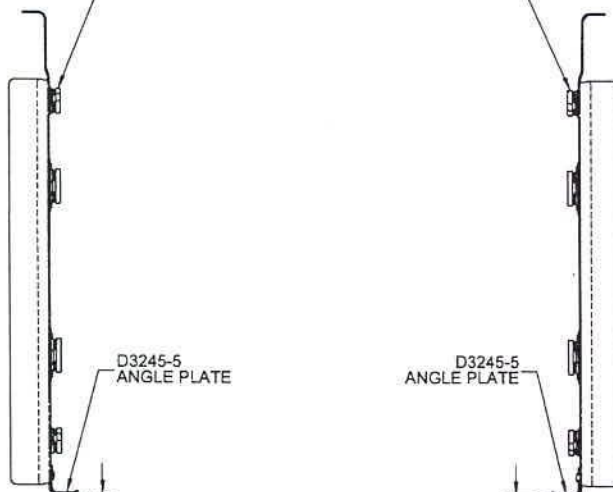
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

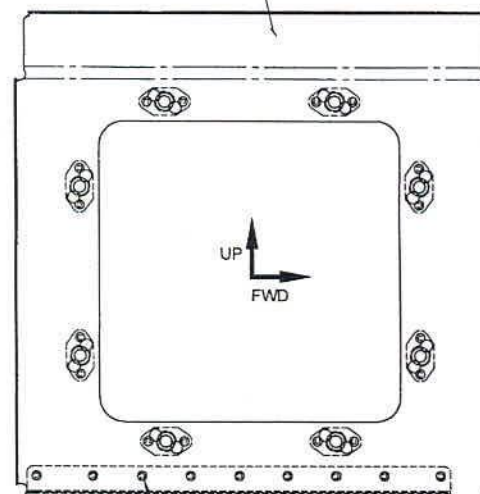


D3245-5
ANGLE PLATE

0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

RELEASED
187 07-10-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1/1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3245 TITLE ACCESS PANEL ASSEMBLY SCALE 1:2.5 COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. B	
DATE	07.10.02	SHEET 1 OF 7	

WORK ORDER NO. 35650
 UNCONTROLLED COPY
 SUBJECT TO SUPPLEMENT
 WITH NOTICE
 ENGINEERING
 RETURN TO
 SHOP COPY
 187 07-10-23